

5/46

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24735
<b>Description:</b> Clevis	<b>Part Number:</b>	D3453-3
<b>Dwg:</b> D3453 Rev. A	<b>Qty:</b>	5
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JF	05.11.09	5
2	MC	Turn as per Folio FA578 Rev: <u>N/A</u> & Dwg D3453 Rev: <u>A</u> Material: AISI 304 SS Round Bar Ø1.250 (M304R1.250) Batch: <u>716889</u> Identify for D3453-3	J.G	05/11/10	5
3	QC2	Inspect parts as they come off the machine	J.G	05/11/10	5
4	QC8	Second check	BG	05.11.10	5
5	MV	Mill as per Folio FA578 Rev: <u>AA</u> & Dwg D3453 Rev: <u>A</u> Identify as D3453-3	BL	05.11.20	5
6	QC2	Inspect parts as they come off the machine	BL	05.11.21	5
7	QC8	Second check	SA	05.11.21	5
8	MV	Deburr	BL	05.11.21	5
9	QC5	Inspect work to Step 8	BL	05.11.21	5
10	ST	Identify and Stock	6.9/12	05/11/22	5
11	AC	Cost / part: <u>13.89</u>	Jus	05-11-23	5
12	DC	Close W/O <u>13.89</u> Inspect Level 21	DP	05/11/23	5

Rev	Date	Change	Revised By	Approved
A	05.09.27	New issue	KJ/EC	EC

**RELEASED**  
EC 05.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 09, 2005  
11:30 am

Work Order No : 0024735  
Project Name : D3453-3  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3453-3  
Description : Clevis  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 11-09-05  
Est Finish Date : 11-11-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

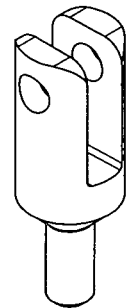
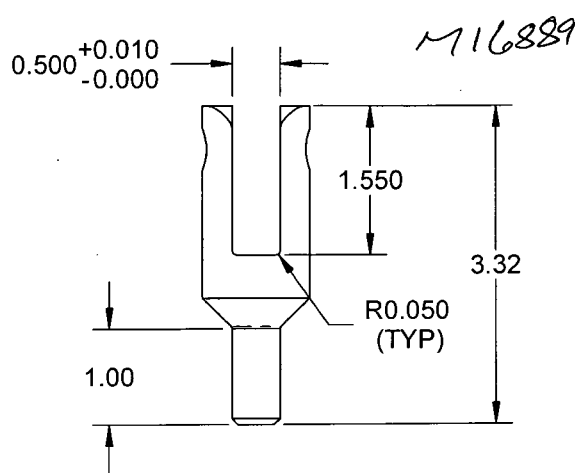
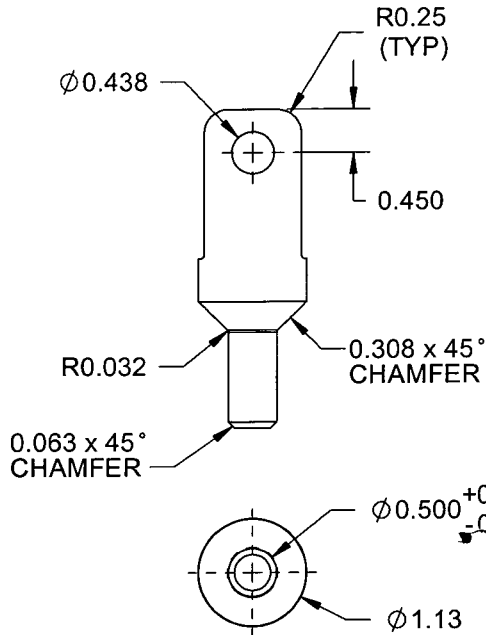
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

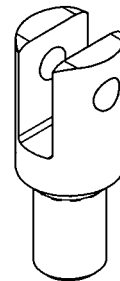
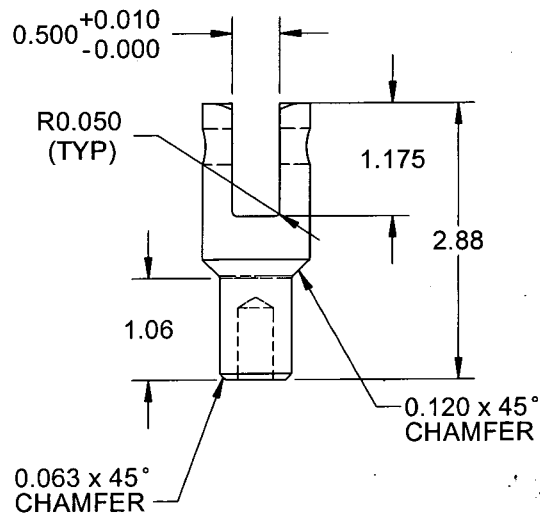
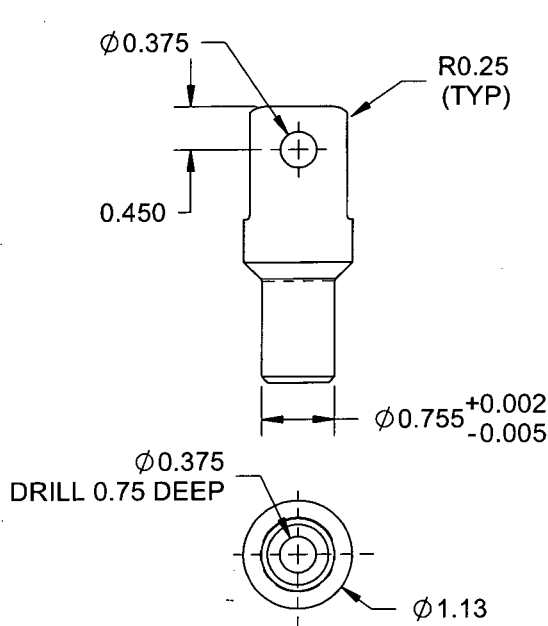


# PRELIMINARY ISSUE

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3453</b>	REV: A SHEET 1 OF 2
DATE <b>05.09.02</b>	TITLE <b>CLEVIS</b>		SCALE 1:2
A	05.09.02	NEW ISSUE	



**D3453-1 CLEVIS**



**D3453-3 CLEVIS**

**NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 21, 2005  
10:12 am

Work Order No : 0024735  
Project Name : D3453-3  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3453-3  
Description : Clevis  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 11-09-05  
Est Finish Date : 11-11-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	4.25	100.00		
Production Cost :	0.00	69.45	100.00	0.00	69.45
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	4.25	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	69.45	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	69.45			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	( -69.45)

Date: Monday, 11/21/2005 10:31:37 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: CLEVIS
<b>Job Number</b>	: 24735		
<b>Estimate Number</b>	: 10578		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D34533
<b>This Issue</b>	: 11/21/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3453
<b>First Issue</b>	: / /	<b>Project Number</b>	:
<b>Previous Run</b>	:	<b>Drawing Revision</b>	: A
	<b>Type</b> : MACHINED PARTS	<b>Material</b>	:
<b>Written By</b>	: _____	<b>Due Date</b>	: 11/28/2005
<b>Checked &amp; Approved By</b>	: _____	<b>Qty:</b>	5
<b>Comment</b>	: A 05.09.27 New issue EC	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304R1250	Inventory
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**Comment:** Qty.: 0.2452 f(s)/Unit Total : 1.2260 f(s)  
 Material: AISI 304 SS Round Bar Ø1.250  
 (M304R1.250)  
 Batch: \_\_\_\_\_

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 1-Turn as per Folio FA578 Rev: \_\_\_\_\_ & Dwg D3453 Rev: \_\_\_\_\_  
 2- Deburr as per dwg D3453

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Mill as per Folio FA578 Rev: \_\_\_\_\_ & Dwg D3453 Rev: \_\_\_\_\_  
 2- Deburr as per dwg 3453

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Date: Monday, 11/21/2005 10:31:37 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 24735

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

